

Date: Tuesday, 19/08/2008 4:03:56 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLAMP
Job Number :	41428		
Estimate Number :	10267		
P.O. Number :		Part Number :	D2438
This Issue :	19/08/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2438 REV. C
First Issue :	/ /	Project Number :	N/A
Previous Run :	39440	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	JUL 08-8-19	Due Date :	30/09/2008
Comment :	Est: E 05.06.28 Bending removed KJ/JLM		

Qty: 200 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 7002

Laser cut as per Dwg D2438

Material release note is required

C268108121

(200)

2.0	D2438B	Clamp
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

P 8/17

(200)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

S 081016

(200)

center

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

B 8-10-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:03:56 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 41428

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

08/10/17 (200)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



sq

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 456

8/10/20

(200)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CMF 08-10-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

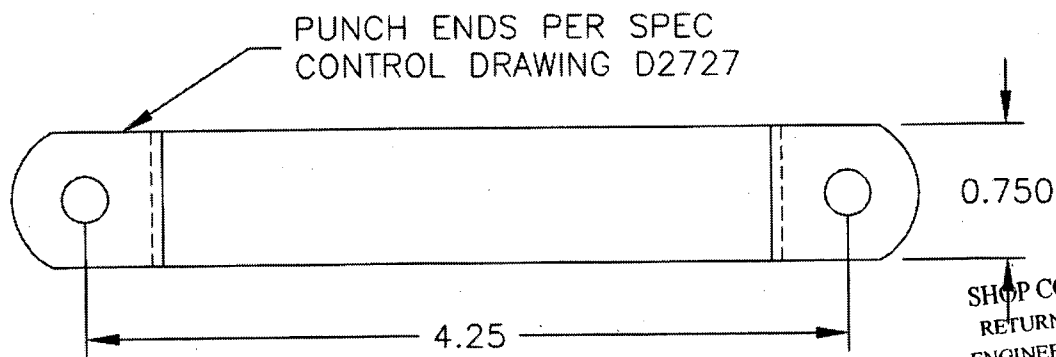
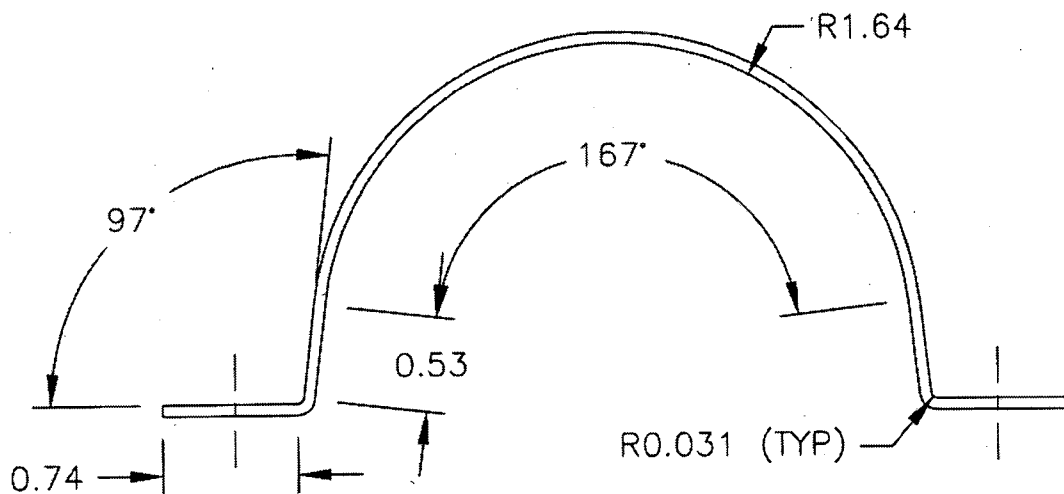
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>W</i>	APPROVED <i>KS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *41428*

00.06.06
P 00.06.07



180 AVENUE LABROSSE
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1
TÉL.: (514) 630-4877 - FAX: (514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VIENDU À / SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7



BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON SHIPPING DATE	N° BON DE LIVRAISON SHIPPING MEMO NO
2008/09/15	0402771

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299	J0189516	PO00007002	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION	
200	D2438	CLAMP	
		S 08/09/15	

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE-CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 18 OUR JOB NO J0189516 SHIPPING MEMO 0402771 *oslokes*

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>200 PCS</u>	<u>PO00007002</u>	<u>D2438B</u>	<u>C</u>	<u>CLAMP</u>	<u>C</u>
MATERIAL		SUPPLIED BY			MAT. REL. NO.	
<u>S.S.T 304</u>		<u>TW METALS / NORTH AMERICAN</u>			<u>2M89</u>	

	PROCESS	PROCESSOR	RELEASE NOTE #
1	<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>	<u>GFI</u>	<u>CONFORMS</u>
2	<u></u>	<u></u>	<u></u>
3	<u></u>	<u></u>	<u></u>
4	<u></u>	<u></u>	<u></u>
5	<u></u>	<u></u>	<u></u>
6	<u></u>	<u></u>	<u></u>
7	<u></u>	<u></u>	<u></u>
8	<u></u>	<u></u>	<u></u>
9	<u></u>	<u></u>	<u></u>

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 16 SEPTEMBER 2008

G.F.I. Q.C. REP. *Dattan*

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME

GFI

PURCHASE ORDER No.

0073680

ITEM No.

0001

SHIPPER INVOICE No.

03235765

MATERIAL

304 S/S Sheet

SPECIFICATION:

ASTMA 240/06

MANUFACTURING MILL

North American Stainless

SIZE

0625

HEAT / LOT No.

2MB9

PART No.

TS06348X964A

QUANTITY:

206 lb.

order

TEST DEPARTMENT CLERK

Jessie Clark

AUTHORITY

Joe Schab

Director of Quality Assurance



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Chent, KY 41045-9615
(502) 347-6000

Certificate: 363977 01 Mail To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Ship To:
FERGUSON METALS INC.
3475 SYMMES ROAD
HAMILTON, OH 45015

Date: 8/06/2007 Page: 1

Steel: 304/304L

Finish: 2B

Your Order: 01009951

NAS Order: AN 0371411 01

Corrosion: ASTM A262/02aB; 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/06b, 480/06b, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
QQS766D-A XMGP, AMS5511H/5513H XMR&FN, MIL4043B, AMD3, XCRNMEAS&FN

REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.
EN 10204 3.1; QQS763F Cond A; RoHS Compliant
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
042MB9 A	* 042MB9 A	.0620	48.0000	13,230 COIL	1299.8	11	1	
042MB9 B	* 042MB9 B	.0620	48.0000	13,330 COIL	1309.6	11	1	

CHEMICAL ANALYSIS

Heat	CM	C	CO	CR	CU	MN	MO	N	NI	P	S	SI
2MB9	US	.027	.115	18.194	.254	1.795	.249	.077	8.120	.033	.001	.419

MECHANICAL PROPERTIES

Product ID #	Coil #	l d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
042MB9 A	042MB9	F T	99.31	51.02	51.13	88.00	85.50
042MB9 B	042MB9	F T	99.31	51.02	51.13	88.00	85.50

REVIEWED BY Q.C.

Date 8/6/07 by *[Signature]*

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

8/0 307

UNITED PERFORMANCE METALS

This is to certify that in accordance with the records in our files the material shipped on your purchase order conforms to the following.

Hamilton, OH 45015

3475 Symmes Road

48 X 120

P.O. # 008265
Sales # 01104122
QTY: 15

00
AS Pick Up

8/08

M49187078

Authorized Signature

Lynne Harper